

Work Order ID 69010

Wednesday, April 27, 2011 10:09:17 AM



Page 1

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 4/27/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-09-27 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3916

A

100

Weld per dwg A/R S.S. rod Batch: 115778 0.00



Large Fab

Large Fab

Memo

0.00

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size as per dwg D3916
- 4- Drill and chamfer holes as per dwg D3916-1 using DT9605
- 5- weld bushing as per dwg D3916
- 6- grind welds flush

SAD 11-05-20

6

11.05.24 6

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

8 11/05/24

x6

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

Item ID: D3916-041

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/10/24



130

Identify as per dwg & Stock Location: W4

0.00



Packaging

Memo

0.00

Packaging

SAA

11-05-25



140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/26

CL 11/05/25

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 27, 2011 10:09:23 AM

Page 1

Work Order ID: 69010

Parent Item: D3916-041

Parent Item Name: Rib Assembly



Start Date: 4/27/2011

Required Date: 5/3/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|---------|--|--------------|----|--|--|-----|------|----------|---|----|--|--|--|
| D3759-1 | | Manufactured | No | | | 100 | Each | 256.0000 | 7 | 42 | | | |
| | | | | | | | | | | | | | |
| Bushing | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA005 | 256 | |
| 66489 | 56 | |
| 66870 | 200 | |

| | | | | | | | | | | | | | |
|---------------------------|--|-----------|----|--|--|-----|---|----------|-------|----------|--|--|--|
| M304TS0.750W.049 | | Purchased | No | | | 100 | f | 105.2263 | 4.166 | 26.31158 | | | |
| | | | | | | | | | | | | | |
| 304 SQ Tube .75x.75x.049W | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT018 | 26.5381 | |
| 117029 | 26.5381 | |
| MAT034 | 78.6882 | |
| 117337 | 78.6882 | |

m117636 → 26.3116

11.05.10

11-05-09

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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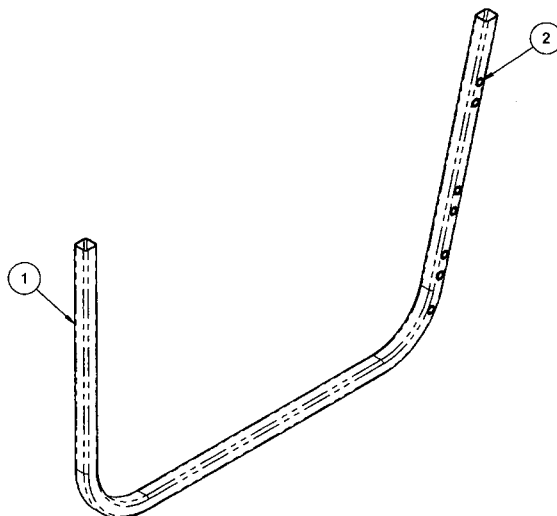
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

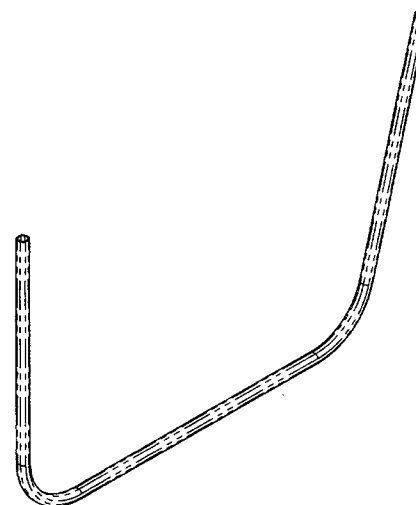
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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|-------------|
| | X | D3916-041 | RIB ASSY |
| 1 | 1 | D3916-1 | RIB |
| 2 | 7 | D3759-1 | BUSHING |



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69010

PL11-04-27

OL-10.12.21
UNDER REVIEW
10.10.4
ADDITION OF HOLE + BUSHING
ON D3916-041-1 RIBS.

RELEASED
2010-03-12
MP

| | | | |
|--|--------------------|--|--------------------|
| A | NEW ISSUE | JPH | 10.03.04 |
| REV. | | DESCRIPTION | BY DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | <i>[Signature]</i> | | |
| MFG. APPR. | <i>[Signature]</i> | | |
| APPROVED | <i>[Signature]</i> | | |
| DE APPR. | <i>[Signature]</i> | | |
| DATE | 10.03.04 | | |
| | | | DRAWING NO. REV. A |
| | | D3916 SHEET 1 OF 4 | |
| | | TITLE SCALE | |
| | | RIB ASSY, 350 BASKET NT | |
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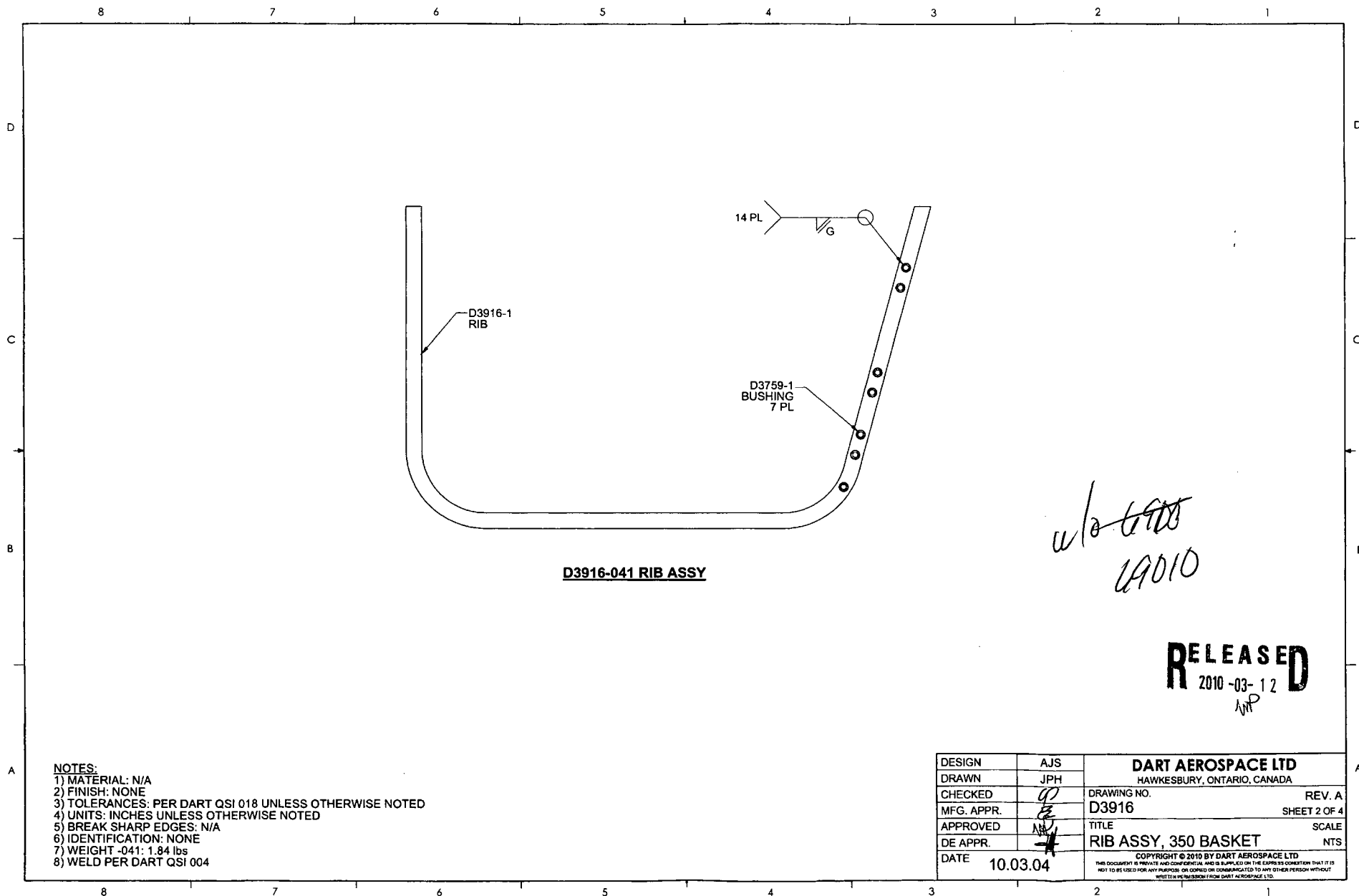
| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries



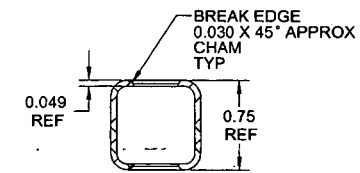
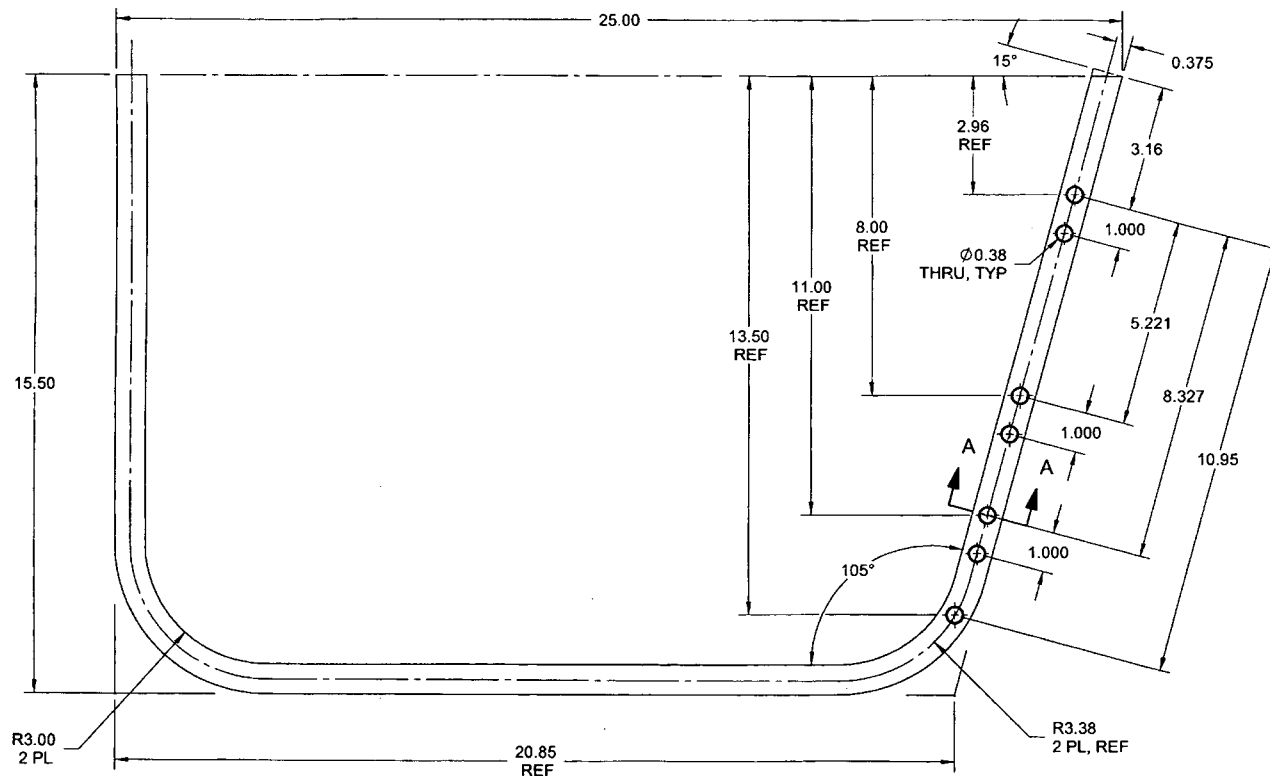
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NOTE: Date & initial all entries







SECTION A-A

w/o 69010

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

| | | | |
|--|---|--|--------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED |  | DRAWING NO. D3916 | REV. A |
| MFG. APPR. |  | SHEET 3 OF 4 | |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | RIB ASSY, 350 BASKET | |
| DATE | 10.03.04 | NTS | |
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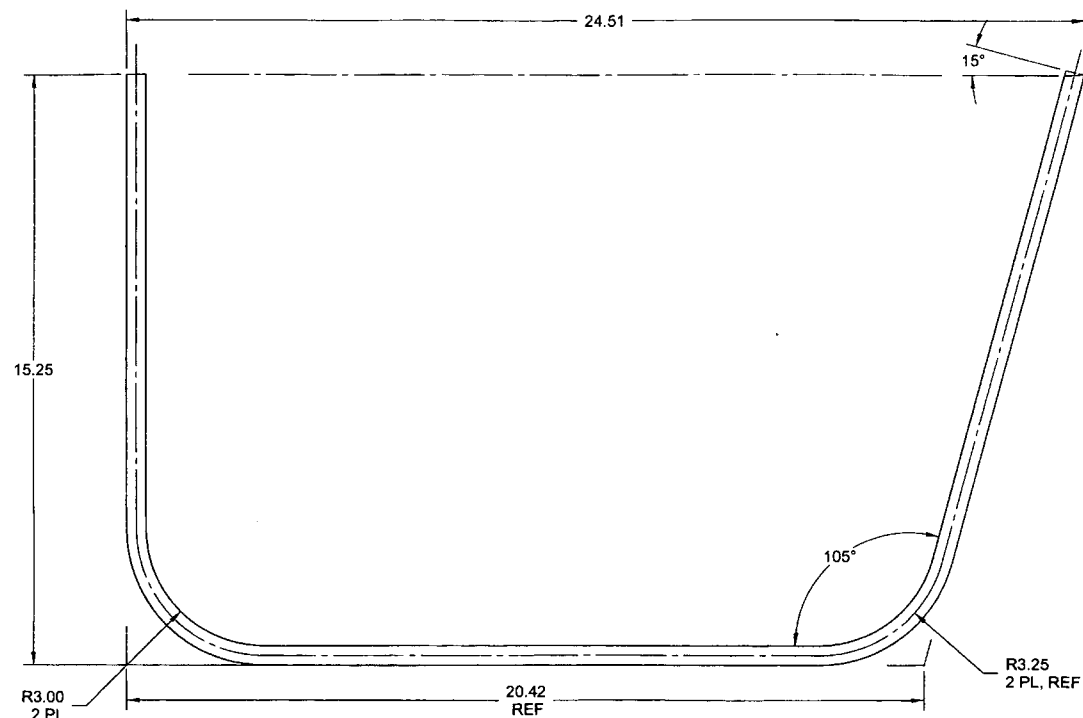
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NOTE: Date & initial all entries



9 D3916-5 LIGHT RIB

u/o 69010

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

| | | | |
|------------|--------------------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D3916 | SHEET 4 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | RIB ASSY, 350 BASKET | NTS |
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